

Turning Profile Insert

A08-010

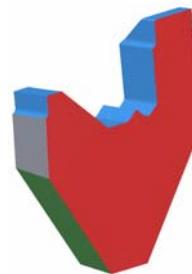
The one sided profiled insert is ground totally in one setup using the TTC-clamping system. The operations include the reference faces, sizing the width, pregrinding and finishing the profile as well as the chipbreaker. Quinto automatically considers the distortions given by the turning parameters, chipbreaker- and holderangles.



1. Cycletime for Production

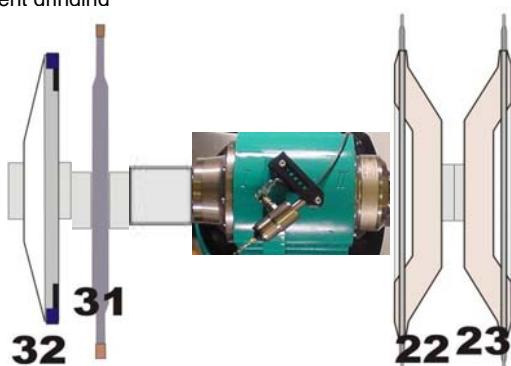
Tool specifications Semitriangle 32x22x5.7 Material CARBIDE					
Operations	Probe	Ref. Faces	Prf Rough	Prf Pregr	Prf fin
Feed [mm/Min]	2000	70	20	35	45
Power [kW]		1	2	1	1
Cutting feed [m/s]		22	22	22	22
Used wheels					
Grinding time [s]	10	65	170	95	76
Total cycle time	8 Min 33				

The mentioned cycle times are indicative. The material to be ground, different arindina wheels or other coolants can influence the cycle times considerably.



2. Used Grinding Wheels

32 Ø250 12C9 D64
31 Ø250 14A1 D64
23 Ø300 14EE1 D64
22 Ø300 14EE1 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,13.5.08

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